

Date: Monday, 2/11/2008 2:12:03 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, RS, 206  
 Job Number : 37333  
 Estimate Number : 10821  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D26662  
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2666 REV.D  
 Previous Run : 36627 Project Number : N/A  
 Material :  
 Due Date : 2/28/2008 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : 08 02 11  
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house  
 processEC  
 Est Rev:D As per Rev D 07-03-19 JLM

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 2X6X6.25  
 Issue material from stock:  
 Cut Size 2.0 x 6.25 X 6.0  
 Grain Along Long 6.0 Length

Batch No: 634372

85 08/04/24 (10)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 3-Fixturing Inspection last completed on 85 by \_\_\_\_\_  
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  
 7- Deburr

85 08/04/24

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

85 08/04/26

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

85 08/04/24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Monday, 2/11/2008 2:12:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 37333

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

24 08/04/29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/04/30

10X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

41 08-04-30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

08/04/30

10X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST426

48 08/05/01

10X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01

Job Completion



MF 08-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 37333
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.118	.119	.120	.119		
B	0.100	0.140		.119	.119	.119	.118		
C	2.470	2.510		2.500	2.500	2.500	2.510		
D	0.100	0.180		.165	.165	.170	.170		
E	0.210	0.230		.220	.220	.220	.218		
F	1.313	1.343		1.322	1.322	1.321	1.321		
G	0.240	0.260		.248	.248	.248	.249		
H	0.615	0.685		.665	.665	.665	.665		
I	1.125	1.145		1.135	1.135	1.135	1.135		
J	0.990	1.010		1.000	1.000	1.000	1.020		
K	0.235	0.240		.235	.235	0.236	0.236		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.112	.112	.112	.113		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.000	6.004	6.004	6.005		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.501	.501	.501	.501		
S	0.313	0.318		.313	.313	.313	.313		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.550	.551	.550	.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>RP</i>
Date: <i>08/04/24</i>

Audited by: <i>RP</i>
Date: <i>08/04/24</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 37333
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		.116	.117	.118	0.118		
B	0.100	0.140		.119	.119	.119	.119		
C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		.170	.170	.170	0.170		
E	0.210	0.230		.219	.219	.219	.219		
F	1.313	1.343		1.321	1.321	1.321	1.321		
G	0.240	0.260		.250	.249	.250	0.250		
H	0.615	0.685		.665	.665	.665	.667		
I	1.125	1.145		1.135	1.135	1.135	1.135		
J	0.990	1.010		1.000	0.995	0.995	0.995		
K	0.235	0.240		.236	.236	.236	.236		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.112	0.112	0.112	0.112		
N	1.565	1.585		1.575	1.575	1.575	1.578		
O	5.990	6.010		6.002	6.004	6.004			
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	0.500	0.500	0.500		
S	0.313	0.318		.313	0.314	0.314	0.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.550	.550	.550	0.550		
X	1.674	1.684		1.682	1.682	1.682	1.682		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>DF</i>	<i>DF</i>
Date: <i>08/04/21</i>	<i>08/04/26</i>

Audited by: <i>RP</i>	<i>08/04/21</i>
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 37333
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.100	0.140		0.117	0.117				
B	0.100	0.140		0.119	0.119				
C	2.470	2.510		2.500	2.500				
D	0.100	0.180		0.175	0.175				
E	0.210	0.230		0.223	0.225				
F	1.313	1.343		1.321	1.319				
G	0.240	0.260		0.248	0.248				
H	0.615	0.685		0.667	0.660				
I	1.125	1.145		1.134	1.132				
J	0.990	1.010		0.995	0.995				
K	0.235	0.240		0.236	0.236				
L	0.510	0.515		0.510	0.510				
M	0.100	0.120		0.112	0.112				
N	1.565	1.585		1.576	1.574				
O	5.990	6.010		6.002	6.002				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.499				
R	0.490	0.510		0.500	0.502				
S	0.313	0.318		0.314	0.314				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.363				
V	0.315	0.322		0.321	0.322				
W	0.540	0.560		0.551	0.550				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		0.258	0.260				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>RF</i>	Audited by: <i>RF</i>
Date: <i>08/24/25</i>	Date: <i>08/04/29</i>

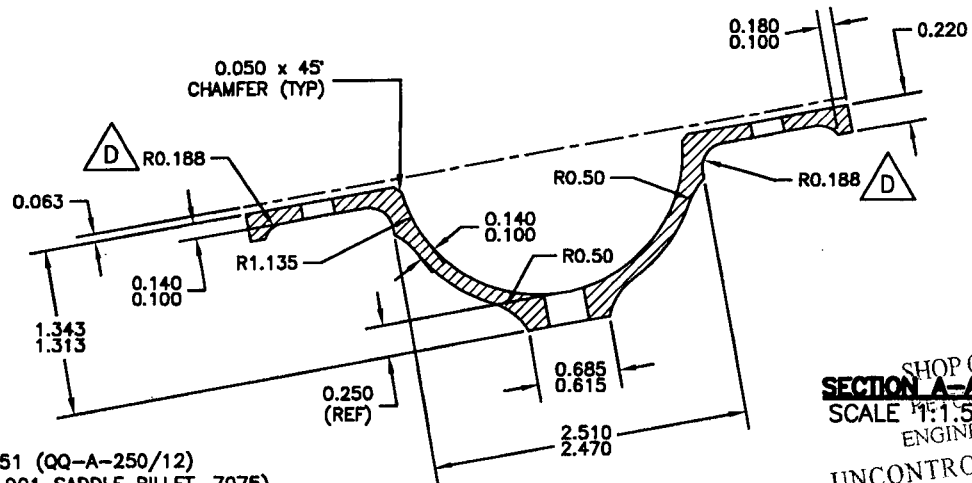
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

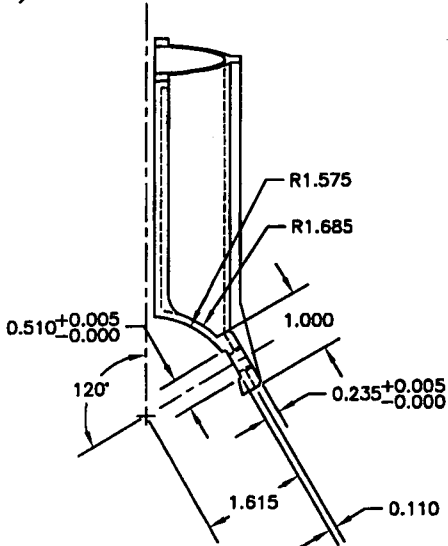
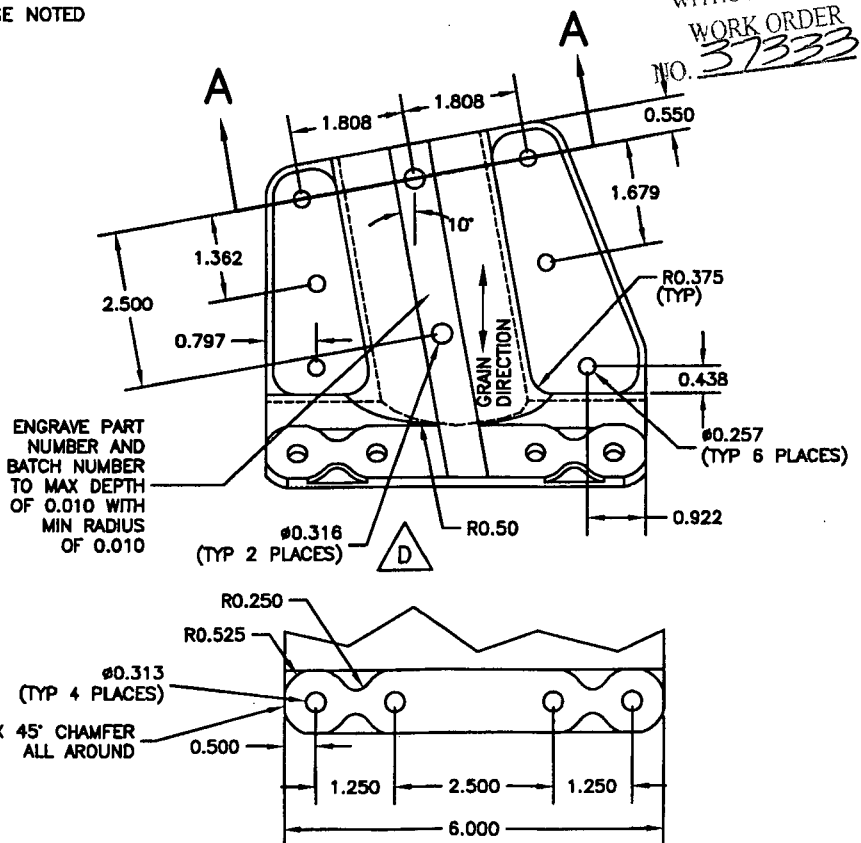
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

07.02.12 [Signature]

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

SHOP COPY  
SCALE 1:1.5  
SECTION A-A  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37333

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



